



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3407-5
Job Sheet 172821



Part No: D3407-5

Job Qty: 40 ea

Part Name: Ring



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No:

Due Date: 3/12/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP Rev:A New Issue 05-11-22 JLM IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		3/10/18	0.00	0.00	Start Up Waterjet		SC 8/03/05
100	Waterjet	40 pcs		3/10/18	0.03	3.66	Waterjet1		SC 8/03/05
110	QC	40 pcs		3/10/18	0.00	0.00	QC2		SC 8/03/05
115	Lathe Conv	40 pcs		3/12/18	0.00	2.64	Lathe Conv-1		W/SC 11-03-13
117	QC	40 pcs		3/12/18	0.00	0.00	QC2		W/SC 11-03-13
120	QC	40 pcs		3/12/18	0.00	0.00	QC8		W/SC 11-03-13
130	Packaging	40 pcs		3/12/18	0.00	0.00	Packaging3		W/SC 11-03-13
140	QC21-SA	40 Ea		3/12/18	0.00	0.00	QC21		W/SC 11-03-13

Part Op 100 - 1-Cut as per Dwg D3407 Dwg Rev: E Prog Rev: E 2-Break edges on manual lathe Dwg D3407 Descriptions: (175rpm)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M174PH-H900B0.250X4.000	17-4 H900 SS Bar 0.250" X 4.000"	10.6400 ft (.266 ea)	90-Start up Operation	

5029859

12A

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M174PH-H900B0.250X4.000	11	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.250inches ± 0.010	0.260 0.240	0.250	
2	Tow Ring	3.000inches ± 0.030	3.030 2.970	3.006	
3	Tow Ring	2.050inches + 0.012 - 0.001	2.062 2.049	2.058	
4	Tow Ring	0.750inches ± 0.030	0.780 0.720	0.753	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																									
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____																																							
Description Work Order Deviation																																											
Completed By _____ Hand / Supervisor _____ Approval _____ QA Coordinator Approval _____ DART AEROSPACE Container No: S047788 Part: D3407-5 Job No: 172821 Serial No/Batch: S047788 Revision: G Inspector: _____ Dart Aerospace Ltd. 1270 Aberdeen Street Harknessburg, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																											
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="3" style="text-align: left;">Root Cause</th> </tr> <tr> <td style="width:33%;">Environment ☐</td> <td style="width:33%;">No Re-verification ☐</td> <td style="width:33%;">Pressure ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/k ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td rowspan="2">OTHER : _____</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>						Root Cause			Environment ☐	No Re-verification ☐	Pressure ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/k ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	Misidentified ☐	Past Due ☐
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